



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-311
Job Sheet 191885



Part No: D350-591-311

Job Qty: 5 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Due Date: 4/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	5 pcs	4/15/19		0.00	4.96	Large Fab - 1		SLn
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
120	QC 9	5 pcs	4/15/19		0.00	0.00	Large Fab - 9		D 19.04.01
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
130	QC 5	5 pcs	4/15/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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140 Handfinish - 1-1 Chemical-B4B	5 pcs	4/15/19	0.00 0.92	QC 5 - 9	DR 19/04/01
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	DR 19/04/01
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	5 pcs	4/15/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	

					QC 7 - 9		APR 01 2019 DAS 68 9-89
					QC 7 - 68		
					QC 7 - 50		
					QC 7 - 67		
					QC 7 - 40		
180 Large Fab - Steps - 2 - B4B	5 pcs	4/15/19	0.00 4.96		Large Fab - 1 - B4B		X4
					Large Fab - 10 - B4B		
					Large Fab - 2 - B4B		
					Large Fab - 3 - B4B		
					Large Fab - 4 - B4B		
					Large Fab - 5 - B4B		
					Large Fab - 6 - B4B		
					Large Fab - 7 - B4B		
					Large Fab - 8 - B4B		
					Large Fab - 9 - B4B		
190 QC 10	5 pcs	4/15/19	0.00 0.00		QC 10 - 10		DAS 24 9-89 APR 05 2019
					QC 10 - 18		
					QC 10 - 24		
					QC 10 - 43		
					QC 10 - 50		
					QC 10 - 58		
					QC 10 - 9		
200 QC 5	5 pcs	4/15/19	0.00 0.00		QC 5 - 10		DAS 24 9-89 APR 05 2019
					QC 5 - 12		
					QC 5 - 17		
					QC 5 - 18		
					QC 5 - 19		
					QC 5 - 22		
					QC 5 - 24		
					QC 5 - 3		
					QC 5 - 42		
					QC 5 - 43		
					QC 5 - 49		
					QC 5 - 51		
					QC 5 - 58		
					QC 5 - 68		
					QC 5 - 9		
					QC 5 - 50		
					QC 5 - 30		
					QC 5 - 40		
210 Handfinish - 1-2- Chemical-B4B	5 pcs	4/15/19	0.00 0.92		Handfinish - 1 - 1 - B4B		D.R 19/04/15
					Handfinish - 1 - 2 - B4B		
					Handfinish - 1 - 3 - B4B		
					Handfinish - 1 - 4 - B4B		
					Handfinish - 1 - 5 - B4B		
					Handfinish - 1 - 6 - B4B		
					Handfinish - 1 - 7 - B4B		
					Handfinish - 1 - 8 - B4B		
					Handfinish - 1 - 9 - B4B		
					Handfinish - 1 - 10 - B4B		
					Handfinish - 1 - 11 - B4B		
					Handfinish - 1 - 12 - B4B		
					Handfinish - 1 - 13 - B4B		
					Handfinish - 1 - 14 - B4B		
					Handfinish - 1 - 15 -		

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					B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
220 Powdercoat - 1 White GI(A)-B4B	5 pcs	4/15/19	0.00 1.45	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
230 Handfinish - 3-1- WingWalk-B4B	5 pcs	4/15/19	0.00 0.92	Handfinish - 3 - 1 - B4B		
				Handfinish - 3 - 2 - B4B		
				Handfinish - 3 - 3 - B4B		
				Handfinish - 3 - 4 - B4B		
				Handfinish - 3 - 5 - B4B		
240 QC 3	5 pcs	4/15/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 26		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 6		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
250 Packaging 1-1 - Pick Kit - B4B	5 pcs	4/15/19	0.00 0.00	Packaging 1 - 1 - B4B		
				Packaging 1 - 2 - B4B		
				Packaging 1 - 3 - B4B		
				Packaging 1 - 4 - B4B		
				Packaging 1 - 5 - B4B		
				Packaging 1 - 6 - B4B		
				Packaging 1 - 7 - B4B		
				Packaging 1 - 8 - B4B		
				Packaging 1 - 9 - B4B		
				Packaging 1 - 10 - B4B		
				Packaging 1 - 11 - B4B		
				Packaging 1 - 12 - B4B		
				Packaging 1 - 13 - B4B		
				Packaging 1 - 14 - B4B		
				Packaging 1 - 15 - B4B		
				Packaging 1 - 16 - B4B		

				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	5 pcs	4/15/19	0.00 0.00	QC 4 - 26	
				QC 4 - 28	
				QC 4 - 42	
				QC 4 - 58	
				QC 4 - 6	DAS
				QC 4 - 69	69
				QC 4 - 9	9-89
				QC 4 - 46	DAS
270 Packaging 3-1 - Stock - B4B	5 pcs	4/15/19	0.00 0.00	Packaging 3 - 1 - B4B	69
				Packaging 3 - 2 - B4B	9-89
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	5 pcs	4/15/19	0.00 0.00	DC - 1 - B4B	DAS 21 APR 22 2019
				DC - 2 - B4B	9-85
280 QC 21 - FG	5 pcs	4/15/19	0.00 0.00	QC 21 - FG - 21	DAS 21 APR 22 2019
				QC 21 - FG - 70	9-85
				QC 21 - FG - 53	9-85

Part Op 110 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig
 Descriptions: DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush
 120 - (QC9- Inspect visual per QSI004- Fusion Welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 180 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.
 190 - (QC10- Inspect visual per QSI004- ground welds)
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (Chemical Conversion Coat per QSI005 4.1)
 220 - (White Gloss (Ref: 4.3.5.1) per QSI005 4.3-Alum) START TIME: 9:10 OVEN TEMPERATURE: 320°
 FINISH TIME: 9:40 11/51749
 230 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
 240 - (QC3- Inspect Part Finish)
 250 - (Pick Kit)
 260 - (QC4- 100% Inspect kits for completeness)
 270 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPPD350-591-311 Location : FG109
 275 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-311 CHG001
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 pcs (2 ea)	110-Large Fab - Steps - 1	3143328
D3219-1	Plate	10 pcs (2 ea)	110-Large Fab - Steps - 1	① S133950 / ② S13 6224
D3272-1	Step	5 pcs (1 ea)	110-Large Fab - Steps - 1	5166225
D3065-041	Step Leg Assembly	5 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	5165662
D3066-1	Spacer	10 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	5128757
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	517999
AN3-35A	Bolt	10 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5149341
AN4-13A	Bolt	40 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158578
AN5-36A	Bolt	10 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5162648
D2230-3	Mounting Lug	20 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158039
D2618	Bushing	10 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5146466
D2856-400-720	Abrasion Strip 4" X 7.20"	10 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5151059
D3235-1	Mounting Lug	10 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5150055
D3278-041	Support Assembly	5 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5169497
MS21042L3	Nut	10 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5157462
MS21042L4	Nut	40 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166694
MS21042L5	Nut	10 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5149145
NAS1149D0363J	Washer	20 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5152662
NAS1149D0463J	Washer	80 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	5157445
NAS1149D0563J	Washer	20 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167648

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	10	193	0
	D3219-1	10	163	0
	D3272-1	5	0	0
180-Large Fab - Steps - 2 - B4B	D3065-041	5	11	0
	D3066-1	10	167	0
	MS20600-AD4W4	80	3,553	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	10	582	0
	AN4-13A	40	1,827	0
	AN5-36A	10	130	0
	D2230-3	20	135	0
	D2618	10	200	0
	D2856-400-720	10	186	0
	D3235-1	10	240	0
	D3278-041	5	3	0
	MS21042L3	10	3,879	0
	MS21042L4	40	3,600	0
	MS21042L5	10	749	0
	NAS1149D0363J	20	920	0
	NAS1149D0463J	80	7,242	0
	NAS1149D0563J	20	1,551	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S167520



Part: D350-591-311

Job No: 191885

Serial No/Batch: S167520

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 16 of 16 FAA STC SH967NE 0